

CLAIMS

1. A bag comprising a receptacle having a mouth at an upper end, and a plastic zipper attached to said mouth, wherein said zipper comprises first and second zipper strips that extend across said mouth, said first zipper strip comprising a first closure profile and said second zipper strip comprising a second closure profile, said first and second closure profiles being mutually interlockable, said mouth being closed when said first and second closure profiles are interlocked and being open when said first and second closure profiles are disengaged, and wherein said receptacle is made of laminated material, said laminated material comprising first and second layers laminated to each other, said first layer comprising a first material and an odor-eliminating agent.

2. The bag as recited in claim 1, wherein said first layer is an inner layer of said receptacle, and said second layer is an outer layer of said receptacle.

3. The bag as recited in claim 1, wherein said first layer further comprises a corrosion-inhibiting agent.

4. The bag as recited in claim 1, wherein said first layer comprises a web of a first thermoplastic material, said odor-eliminating agent being present in said first thermoplastic material.

5. The bag as recited in claim 4, wherein said second layer comprises a web of a second thermoplastic material having a chemical composition different than said first thermoplastic material, said second thermoplastic material being substantially impermeable to gas.

6. The bag as recited in claim 1, wherein said first zipper strip comprises a first flange joined to said receptacle, and said second zipper strip comprises a second flange joined to said receptacle.

ITW-14510

7. The bag as recited in claim 1, wherein said zipper is a string zipper, each of said first and second zipper strips comprising a respective base joined to said receptacle.

5 8. The bag as recited in claim 2, wherein said first layer is an inner layer of said receptacle, and said second layer is an outer layer of said receptacle, opposing surfaces of said first and second layers forming an interface, at least one of said opposing surfaces having a camouflage pattern printed thereon.

10 9. The bag as recited in claim 1, wherein said receptacle comprises first and second walls joined together along first and second side seals, further comprising first and second header walls projecting upward from said receptacle and joined together along said first and second side seals, said first header wall having a first opening, and said second header wall having a second opening, said first and second openings being generally mutually
15 overlapping when said mouth of said receptacle is closed.

10. The bag as recited in claim 9, wherein said first header wall is integrally connected to said first wall of said receptacle, and said second header wall is integrally connected to said second wall of said receptacle.

20 11. The bag as recited in claim 1, wherein said receptacle comprises first and second walls joined together along first and second side seals, and a gusseted bottom connected to said first and second walls.

25 12. A bag comprising a receptacle having a mouth at an upper end, and a plastic zipper attached to said mouth, wherein said zipper comprises first and second zipper strips that extend across said mouth, said first zipper strip comprising a first closure profile and said second zipper strip comprising a second closure profile, said first and second closure profiles being mutually interlockable, said mouth being closed when said first and second closure profiles are interlocked and being open when said first and second closure profiles are disengaged, and wherein said receptacle is made of laminated

ITW-14510

material, said laminated material comprising first and second layers laminated to each other, opposing surfaces of said first and second layers forming an interface, at least one of said opposing surfaces of said first and second layers having a camouflage pattern printed thereon.

5 13. The bag as recited in claim 12, wherein said first layer further comprises a corrosion-inhibiting agent.

14. The bag as recited in claim 12, wherein said first zipper strip comprises a first flange joined to said receptacle, and said second zipper strip comprises a second flange joined to said receptacle.

10 15. The bag as recited in claim 12, wherein said zipper is a string zipper, each of said first and second zipper strips comprising a respective base joined to said receptacle.

15 16. The bag as recited in claim 12, wherein said receptacle comprises first and second walls joined together along first and second side seals, further comprising first and second header walls projecting upward from said receptacle and joined together along said first and second side seals, said first header wall having a first opening, and said second header wall having a second opening, said first and second openings being generally mutually overlapping when said mouth of said receptacle is closed.

20 17. The bag as recited in claim 16, wherein said first header wall is integrally connected to said first wall of said receptacle, and said second header wall is integrally connected to said second wall of said receptacle.

25 18. The bag as recited in claim 12 wherein said receptacle comprises first and second walls joined together along first and second side seals, and a gusseted bottom connected to said first and second walls.

19. The bag as recited in claim 12, wherein said first layer comprises a web of a first thermoplastic material containing an odor-eliminating agent and said second layer comprises a web of a second thermoplastic

ITW-14510

material, said second thermoplastic material being impermeable to gas.

20. A method of manufacture comprising the following steps:

(a) printing a camouflage pattern on a surface of a first web of film;

5 (b) laminating said first web of film to a second web of film to form a laminated web having first and second mutually parallel edges, said second web of film being optically transparent and said printed surface of said first web of film being trapped between said first and second webs;

10 (c) folding said laminated web along a fold line with said second web disposed on the outside of the fold, said fold line being generally parallel to said first and second edges;

(d) joining a first zipper strip to a first portion of said first web of said laminated web along a first zone of joinder extending generally parallel to said first and second edges;

15 (e) joining a second zipper strip to a second portion of said first web of said laminated web along a second zone of joinder extending generally parallel to said first and second edges;

20 (f) joining a first transverse portion of said laminated web to a second transverse portion of said laminated web to form a first cross seal generally orthogonal to said first and second edges; and

(g) joining a third transverse portion of said laminated web to a fourth transverse portion of said laminated web to form a second cross seal generally parallel to said first cross seal and separated therefrom by a predetermined distance,

25 wherein said first and second cross seals extend from said fold to at least said first and second zipper strips.

ITW-14510

21. The method as recited in claim 20, further comprising the step of interlocking said first and second zipper strips together.

22. The method as recited in claim 20, wherein step (c) is performed subsequent to steps (d) and (e), and prior to steps (f) and (g).

5 23. The method as recited in claim 20, wherein step (c) is performed prior to steps (d) through (g).

24. The method as recited in claim 20, wherein step (c) is performed subsequent to step (d) and prior to steps (e) through (g).

10 25. The method as recited in claim 20, further comprising the steps of cutting said folded laminated web along said first and second cross seals.

15 26. The method as recited in claim 20, wherein said first zone of joinder is separated from said first edge by a first marginal portion of said laminated web, and said second zone of joinder is separated from said second edge by a second marginal portion of said laminated web, further comprising the steps of forming a first opening in said first marginal portion and forming a second opening in said second marginal portion, said first and second openings being centrally disposed between said first and second cross seals.

27. A method of manufacture comprising the following steps:

20 (a) blending resin containing odor-eliminating agent with resin for making bag making film;

(b) extruding a first web of film using said blended resins;

(c) laminating said first web of film to a second web of film to form a laminated web having first and second mutually parallel edges;

25 (d) folding said laminated web along a fold line that lies generally parallel to said first and second edges;

ITW-14510

(e) joining a first zipper strip to a first portion of said first web of said laminated web along a first zone of joinder extending generally parallel to said first and second edges;

5 (f) joining a second zipper strip to a second portion of said first web of said laminated web along a second zone of joinder extending generally parallel to said first and second edges;

(g) joining a first transverse portion of said laminated web to a second transverse portion of said laminated web to form a first cross seal generally orthogonal to said first and second edges; and

10 (h) joining a third transverse portion of said laminated web to a fourth transverse portion of said laminated web to form a second cross seal generally parallel to said first cross seal and separated therefrom by a predetermined distance,

15 wherein said first and second cross seals extend from said fold to at least said first and second zipper strips.

28. The method as recited in claim 27, further comprising the steps of cutting said folded laminated web along said first and second cross seals.

20 29. A bag comprising a receptacle having a mouth at an upper end, and a plastic zipper attached to said mouth, wherein said zipper comprises first and second zipper strips that extend across said mouth, said first zipper strip comprising a first closure profile and said second zipper strip comprising a second closure profile, said first and second closure profiles being mutually interlockable, said mouth being closed when said first and second closure profiles are interlocked and being open when said first and second closure profiles are disengaged, and wherein said receptacle is made of laminated material, said laminated material comprising first and second layers laminated to each other, said first layer comprising a thermoplastic material and a

25

ITW-14510

corrosion-inhibiting agent.